

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020827**Date Inspected:** 26-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -14E

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-128/127.Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-133/132.Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-098/097.Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is

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identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-102/103. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-107/108. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-112/113. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-117/118. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-122/123. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-152/155. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP 3162-001-147/148. Located on DP3162-001. The welder is identified as 044824. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

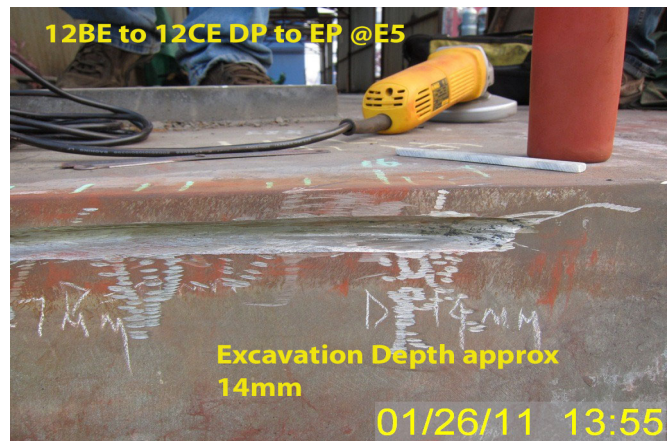
FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-142/143. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-139/138. Located on SEG3019. The welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector executed the excavation of the transverse indications found by AB/F using the Ultrasonic Testing (scanning pattern D method). The location excavated was on the 12BE to 12CE Deck Plate to Edge Plate weld (DP to EP @ E5) Holdback .See pictures below.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By: Teall,Manuel

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer